

Work Order ID 58070



Page 1

April 22, 2010 2:22:13 PM

Item ID: D4048-8

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-4-22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4048	A
-------	---

100 0.00



Bandsaw

Memo

0.00

S.S 10/05/08

2 0

Jeaspa Bandsaw

CUT BLANK 7.320" LONG

110



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA899

DWG REV: A

FOLIO REV: A

DEBURR

MR 10/05/08
SST 10/05/08

2 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4048-8 PAR #: Fault Category: Machining NCR: No DQA: Date: 10/05/19
 Resolution: Accepted Disposition: use as is QA: N/C Closed: Date: 10/05/19

NCR: 58070		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/09	110	the dim. .875 deep in the groove are too small of .005" under tol. 2 parts. RL LDA. not measured correctly on first part.	AP 10.05.10 per Q51042	OK. PART STILL CLEARS TO BING.	MWF 10/05/09	OK 10/05/10	AP 10.05.10 per Q51042	10/05/10

NOTE: Date & initial all entries

Work Order ID 58070

April 22, 2010 2:22:13 PM



Page 2

Item ID: D4048-8

Revision ID:

Item Name: Mounting Lug

Start Date: 4/22/10 Start Qty: 2.00

Accept



Setup Start



Required Date: 4/30/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/05/08

MV= 10/05/08

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

10/05/09

0.00

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

10/05/10

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58070



Page 3

April 22, 2010 2:22:14 PM

Item ID: D4048-8

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114207

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
Qty

2

4

Reject
NumberInsp.
Stamp

Memo

Mask 0.257" holes and indicated channel prior to powder coat

POWDER COAT:

Start Time: 8:00 AM

Oven Temperature: 320°C

Finish Time: 8:20 AM

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

2 BR 10-5-11

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: ST111

0.00

Memo

0.00

10/01/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

April 22, 2010 2:22:14 PM

Item ID: D4048-8

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Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/05/12 *MF**MF*

10-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:22:13 PM

Page 1

Work Order ID: 58070



Parent Item: D4048-8



Parent Item Name: Mounting Lug

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC IPP Rev:B
as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased		No		100	f	17.0000	1.2842			

6061T6 Bar 1.500 x 4.00



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT09	17
113797	17

1.2842

8f 10/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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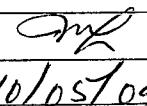
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58070
Description: Mounting Lug	Part Number:	D4048-8
Inspection Dwg: D4048 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.13	± 0.030	4.126	✓			
1.20	± 0.030	1.20	✓			TYP
0.125	± 0.010	0.120	✓			TYP
1.74	± 0.030	1.735	✓			
2.00	± 0.030	2.00	✓			
0.125	± 0.010	0.125	✓			
1.95	± 0.030	1.95	✓			
0.53	± 0.030	0.520	✓			TYP
26°	$\pm 1/2^\circ$	26°	✓			
$\phi 0.435 \times 45^\circ$	$\pm 0.010 / \pm 1/2^\circ$	$0.440 \times 45^\circ$	✓			chamfer 2PL
R0.50	± 0.030	0.50	✓			
$\phi 0.375$	$\pm 0.006 / -0.001$	0.379	✓			
1.79	± 0.030	1.79	✓			
0.93	± 0.030	0.925	✓			
R0.31	± 0.030	0.310	✓			TYP
3.75	± 0.030	3.741	✓			
3.000	± 0.010	3.000	✓			
$\phi 0.257$	$\pm 0.006 / -0.001$	0.261	✓			3PL
1.500	± 0.010	1.500	✓			
0.38	± 0.030	0.37	✓			
0.375	± 0.010	0.375	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/05/06	Date:	10/05/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	58070
Description: Mounting Lug	Part Number:	D4048-8
Inspection Dwg: D4048 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/05/09	Date:	10/05/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

6

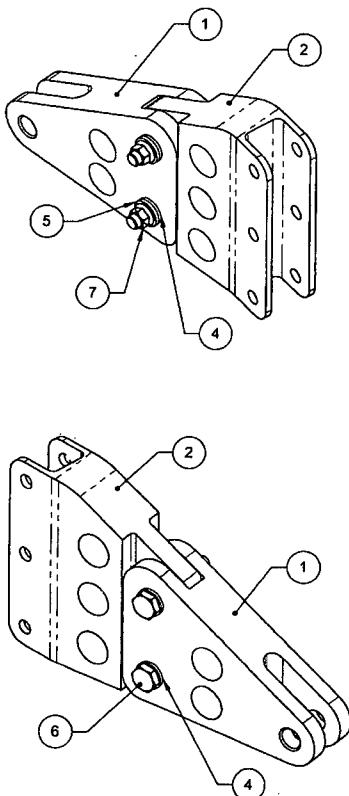
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4

3

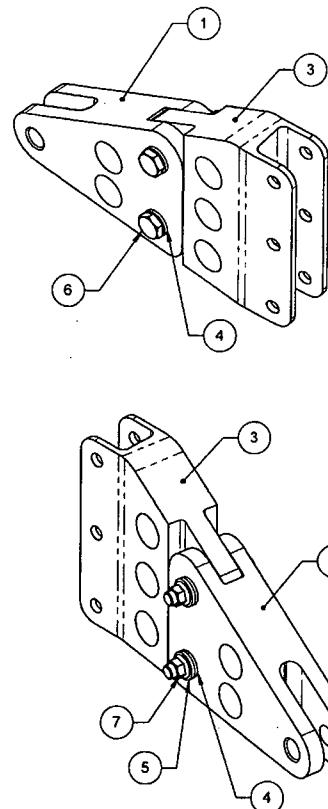
2

1



D4048-041 MOUNTING LUG ASSY (SHOWN)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: D4048-041/-042: 1.16 lbs
 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)



D4048-042 MOUNTING LUG ASSY (SHOWN)

ITEM	QTY -041	QTY -042	P/N	Description
	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 58070

BS10-4-22
 RELEASED
 R 2010-02-16
MD

A	NEW ISSUE	RF	10.01.29	
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		A
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>90</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>90</i>	D4048	SHEET 1 OF 9	
APPROVED	<i>90</i>	TITLE	SCALE	NTS
DE APPR.	<i>90</i>	MOUNTING LUG ASSY		
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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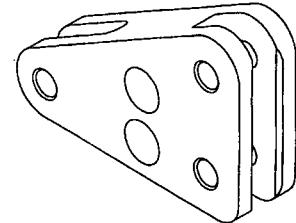
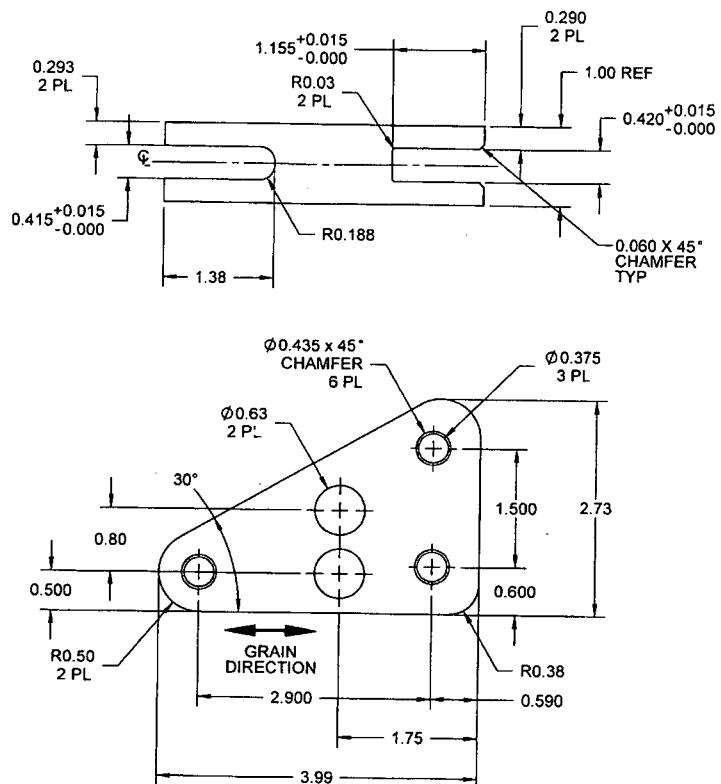
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/o 58870

D4048-1 MOUNTING LUG

NOTES:

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/6 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø.0315 HOLES PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED
2010-02-16
AM

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>99</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>99</i>	D4048	SHEET 2 OF 9	
APPROVED	<i>100</i>	TITLE	SCALE	
DE APPR.	<i>100</i>	MOUNTING LUG ASSY	NTS	
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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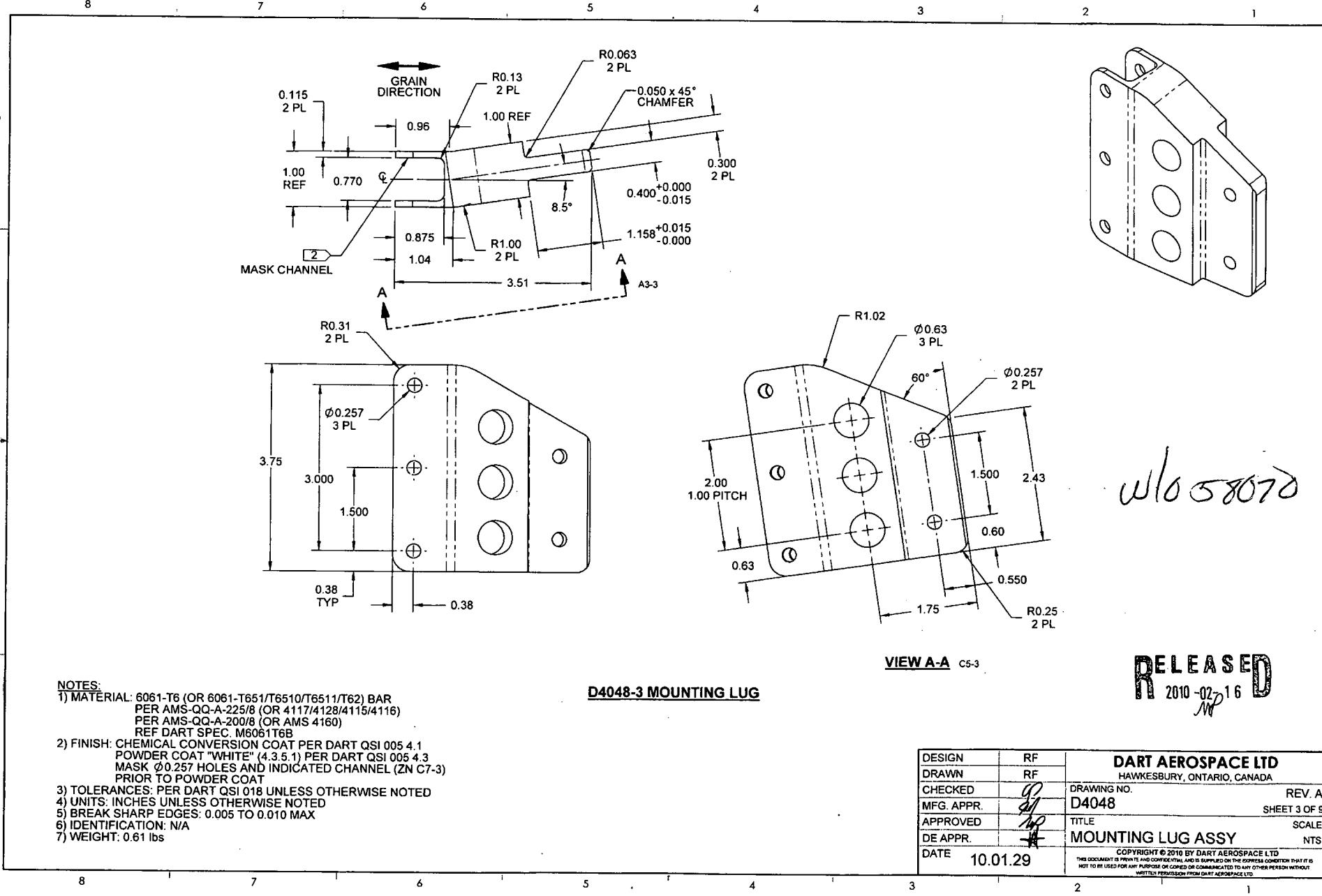
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

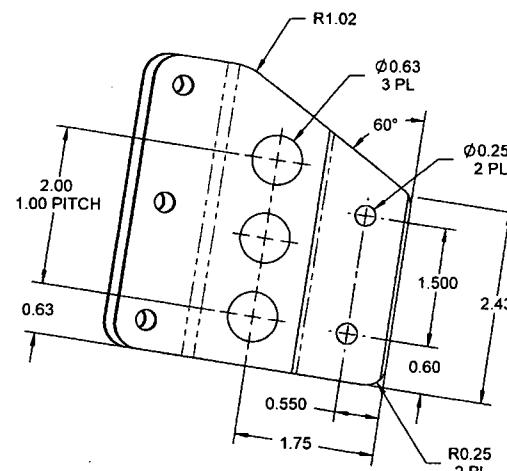
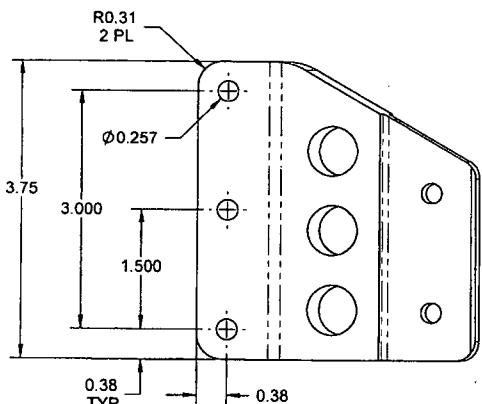
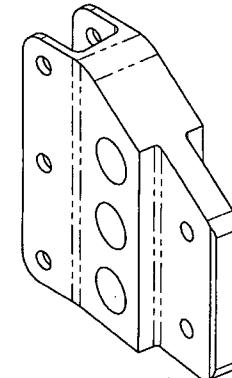
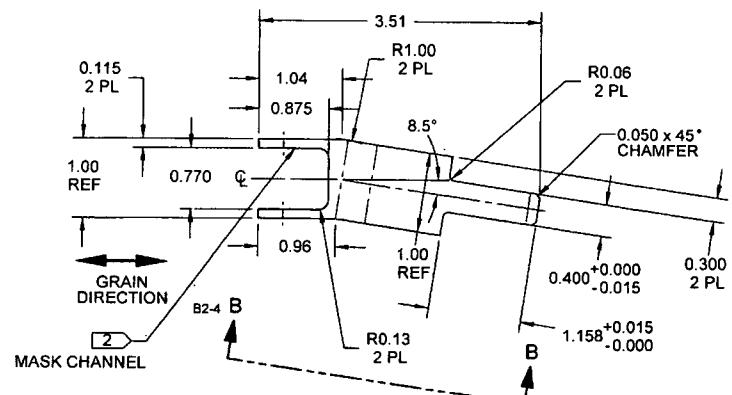


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/058070

RELEASED
2010-02-16
WFO

D4048-4 MOUNTING LUG

VIEW B-B c6-4

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø.0257 HOLES AND INDICATED CHANNEL (ZN C7-4)
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	99	DRAWING NO.	REV. A	
MFG. APPR.	211	D4048	SHEET 4 OF 5	
APPROVED	MP	TITLE	SCALE	
DE APPR.	H	NTS		
DATE	10.01.29	MOUNTING LUG ASSY		

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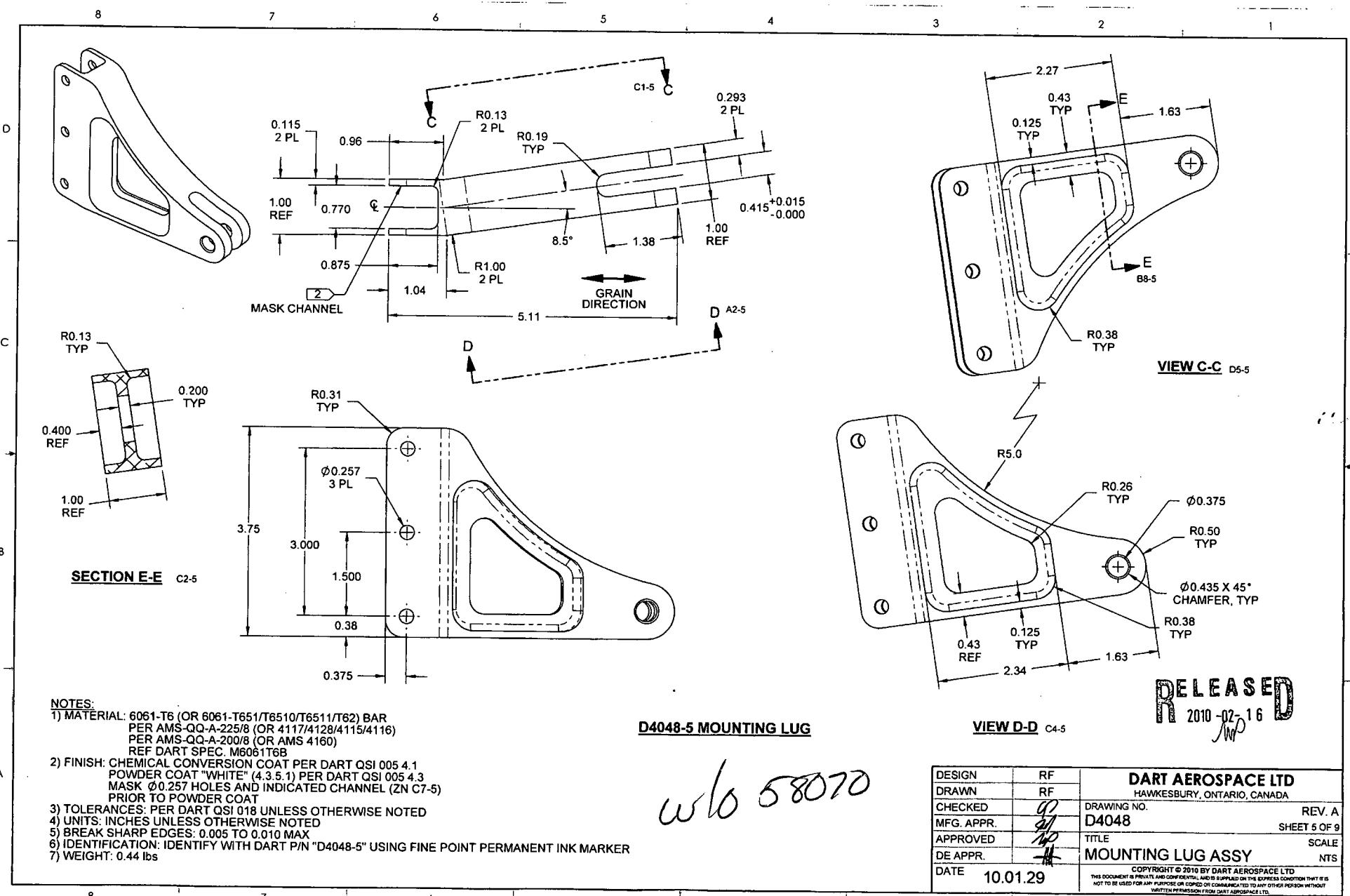
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>g</i>	DRAWING NO.
MFG. APPR.	<i>g</i>	D4048
APPROVED	<i>g</i>	REV. A
DE APPR.	<i>g</i>	SHEET 5 OF 9
DATE	10.01.29	TITLE
		SCALE
		NTS

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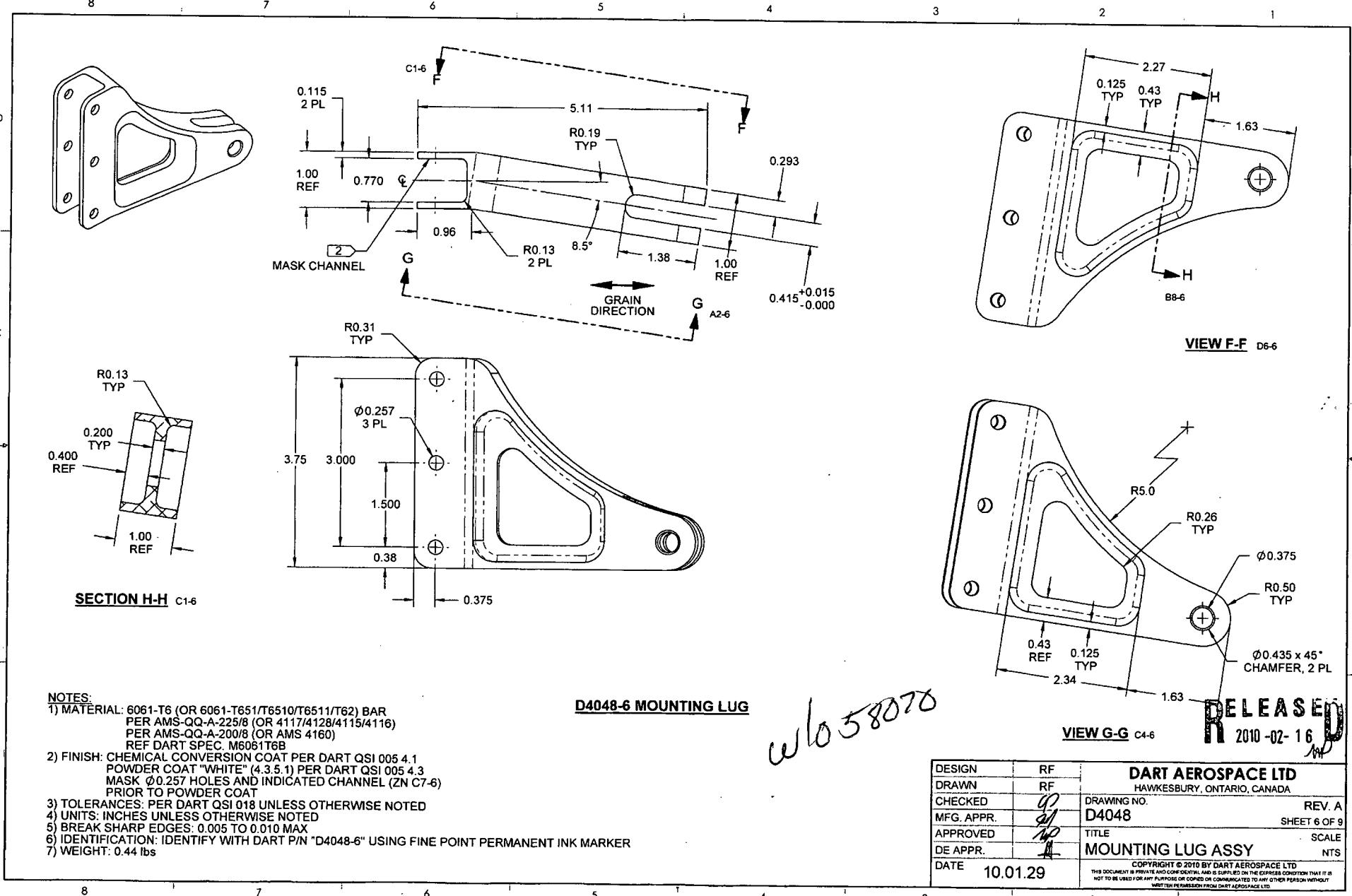
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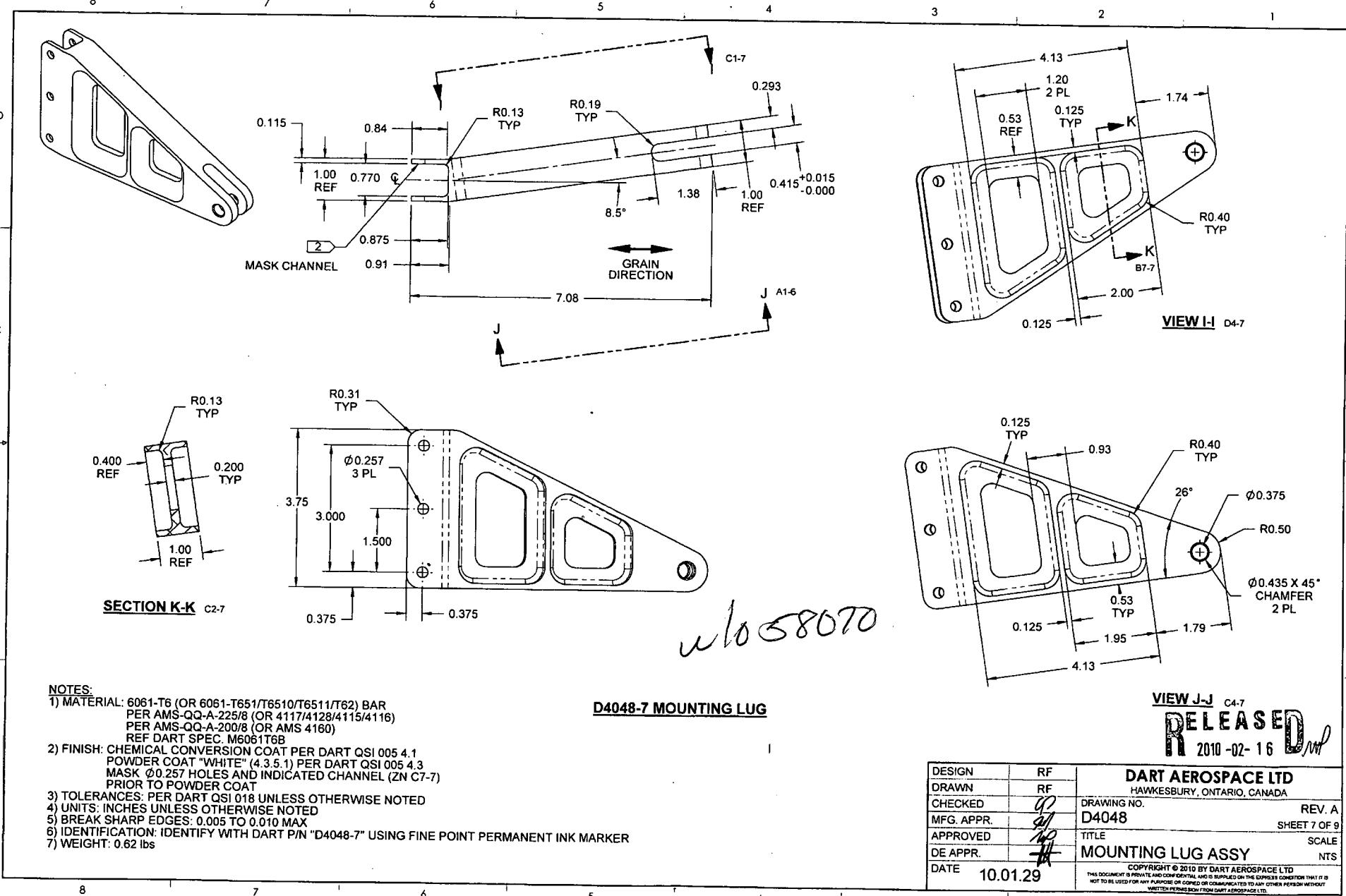


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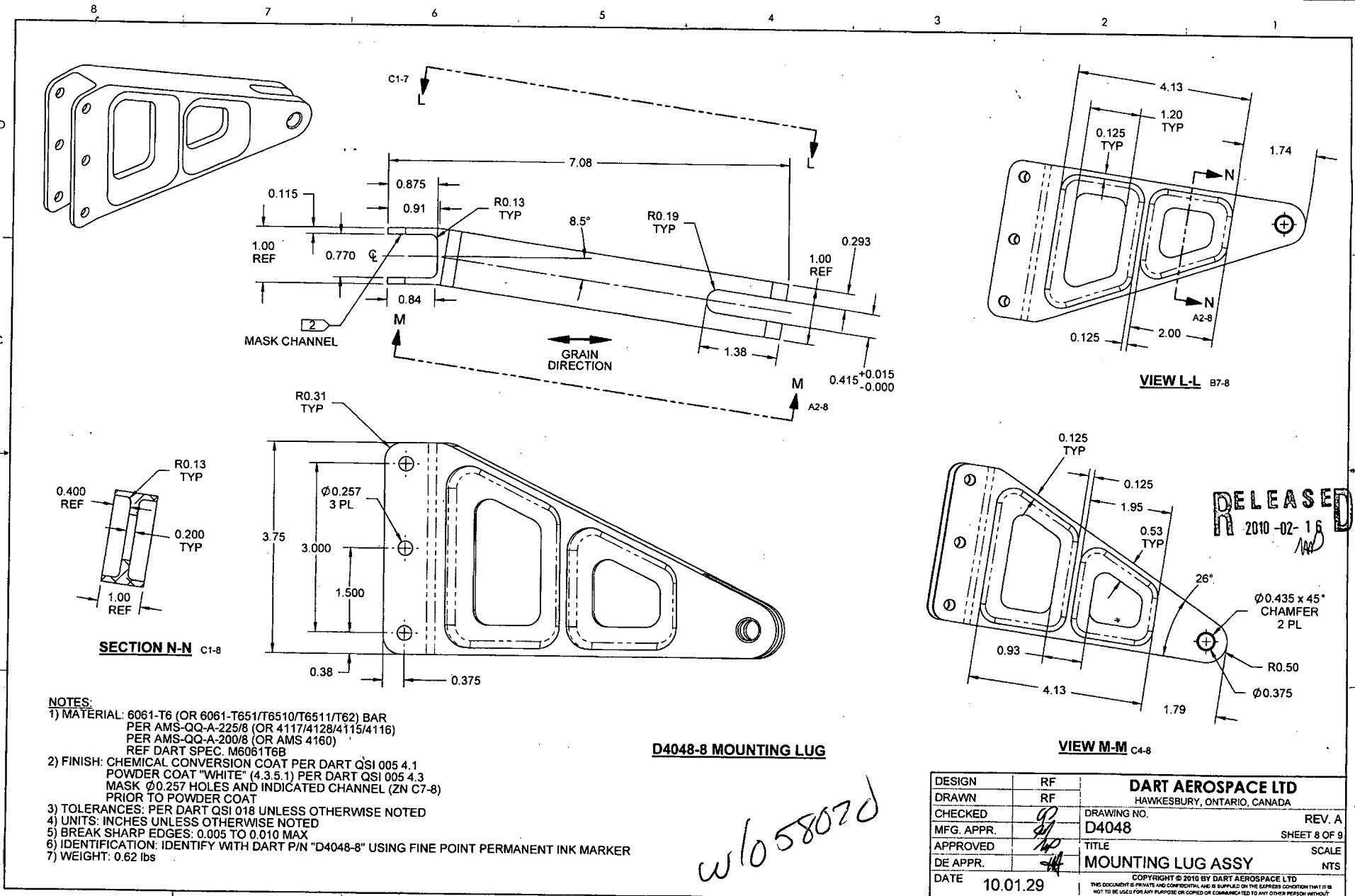
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

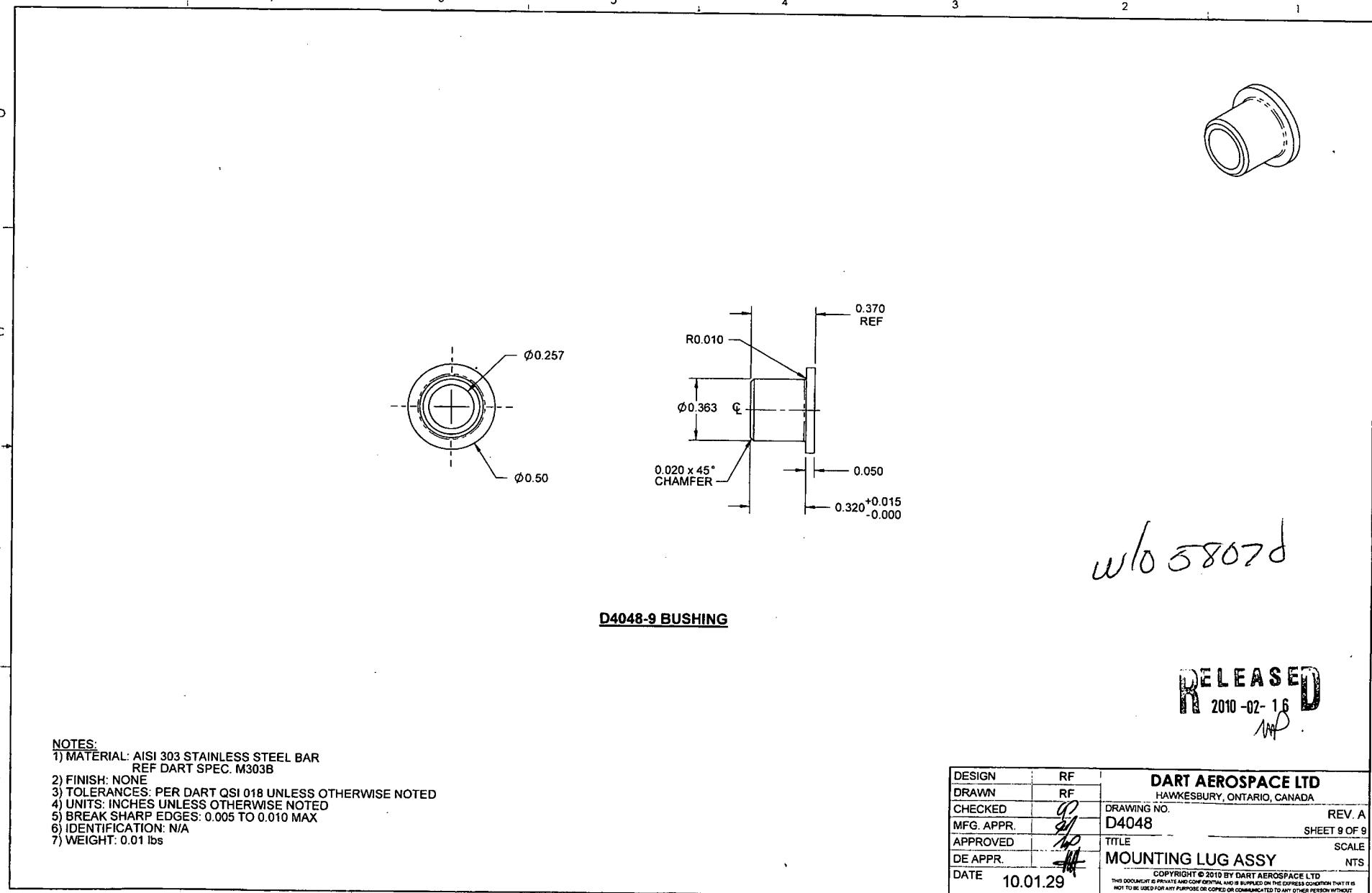
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries